

Date: Thursday, 5/4/2006 11:20:04 AM
User: Kim Johnston

Process Sheet

split
SB 06/06/15

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BLOWER MOTOR ADAPTER
Job Number : 26994 -2	
Estimate Number : 12133	
P.O. Number : N/A	Part Number : D3476043
This Issue : 5/4/2006 S.O. No. : N/A	Drawing Number : D3476 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26618	Material : N/A
Written By : <i>See COMMENT BELOW</i>	Due Date : 5/28/2006
Checked & Approved By : <i>06.05.05</i>	Qty: 8 Um: Each
Comment : Est Rev:A New Issue 06-01-31 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34763	DOMES
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3476-3	blower motor adapter	<i>B25689-2</i>
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2.0	D34767	TUBE
-----	--------	------



Comment: Qty.: 2.0000 Each(s)/Unit Total : 16.0000 Each(s)

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

2	D3476-7	Tube	<i>B27024</i>
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3.0	D34761	duct
-----	--------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 8.0000 Each(s)

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

1	D3476-1	Duct	<i>B27024</i>
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4.0	NAS1031C3W	Nutplate
-----	------------	----------



Comment: Qty.: 4.0000 Each(s)/Unit Total : 32.0000 Each(s)

Qty	Part Number	Description	Batch
-----	-------------	-------------	-------

4	NAS-1031C3W	Nutplate	<i>M601144</i>
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SB 06/07/10 (1)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Spot Weld Tubes And Nut plates as per Dwg D3476 and Dart QSI 018

SB 06/07/10 (1)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: DS Date: 06/08/10

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Thursday, 5/4/2006 11:20:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BLOWER MOTOR ADAPTER

Job Number: 26994

Part Number: D3476043

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5/1000

WELD INSPECTION



Comment: WELD INSPECTION

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 12A

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W 26-08-10

SP 06-08-09 ①

SP 06/08/09 ①

SP 06/08/10 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

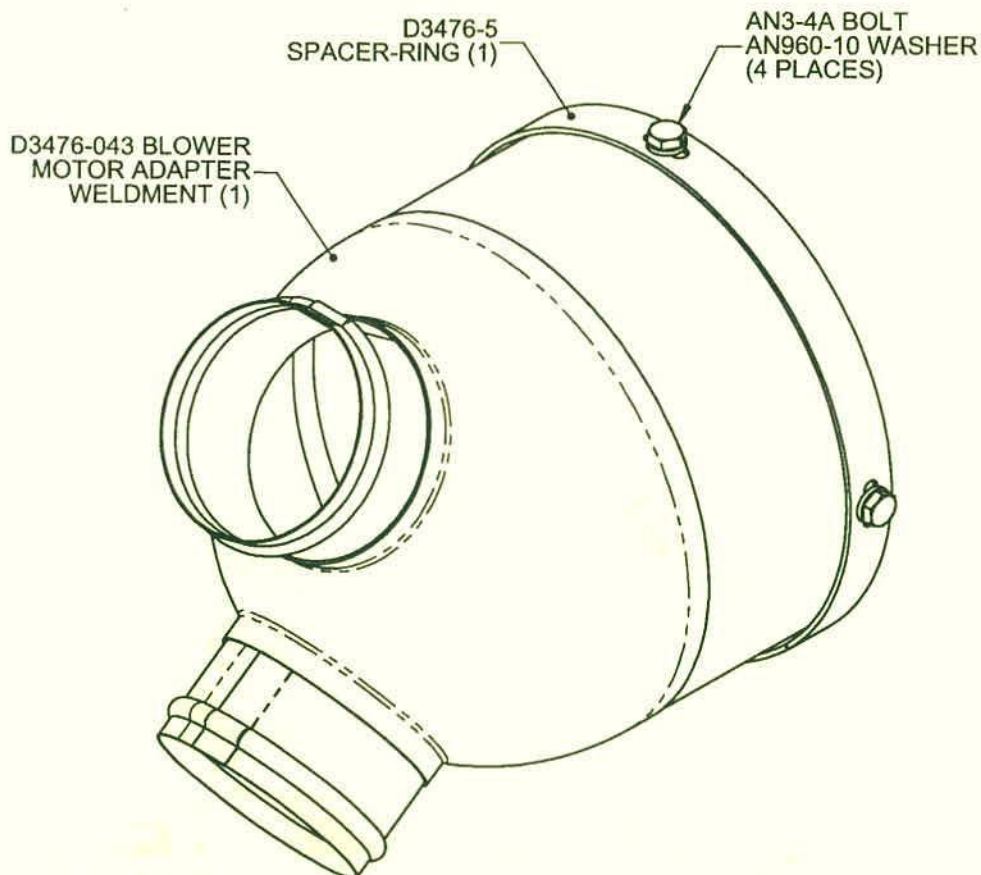
NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



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CHECKED <i>A</i>	APPROVED <i>A</i>	DRAWING NO. D3476	REV. A SHEET 1 OF 7
DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER SCALE 1:2	
A	06.01.27	NEW ISSUE	

A 06.04.03



D3476-041 BLOWER MOTOR ADAPTER

1) IDENTIFY WITH DART P/N D3476-041 USING FINE POINT PERMANENT INK MARKER

QTY -041	P/N	DESCRIPTION
X	D3476-041	BLOWER MOTOR ADAPTER
1	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-5	SPACER-RING
4	AN3-4A	BOLT
4	AN960-10	WASHER

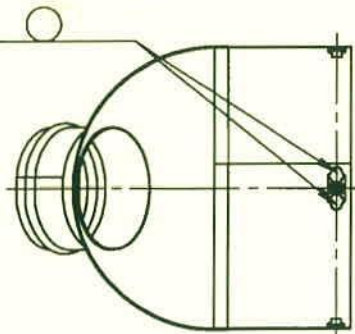
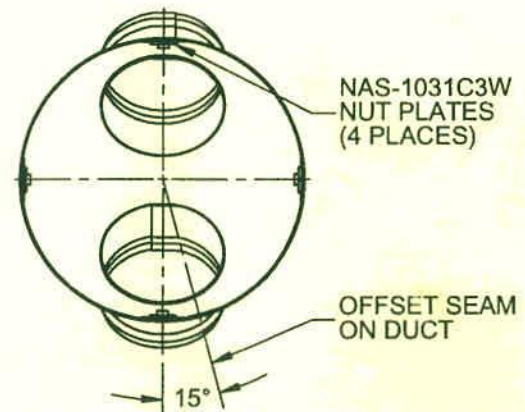
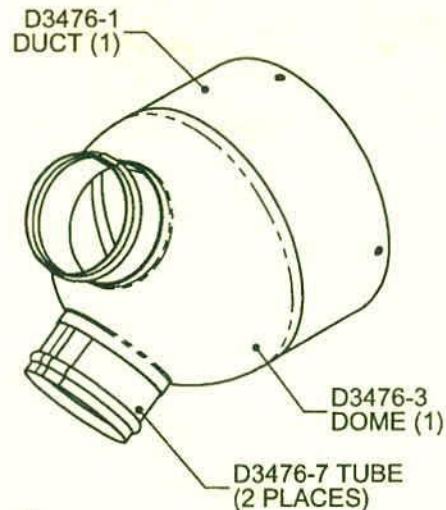
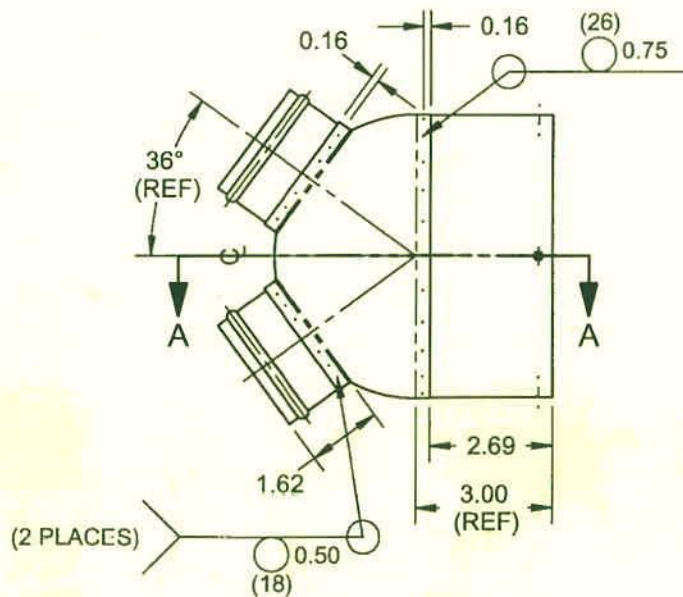
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

LOCATE AND
SPOT WELD
NUT PLATES
(4 PLACES)**SECTION A-A**SHOP COPY
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NO. 26994

**D3476-043 BLOWER MOTOR
ADAPTER WELDMENT****NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) PART IS SYMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

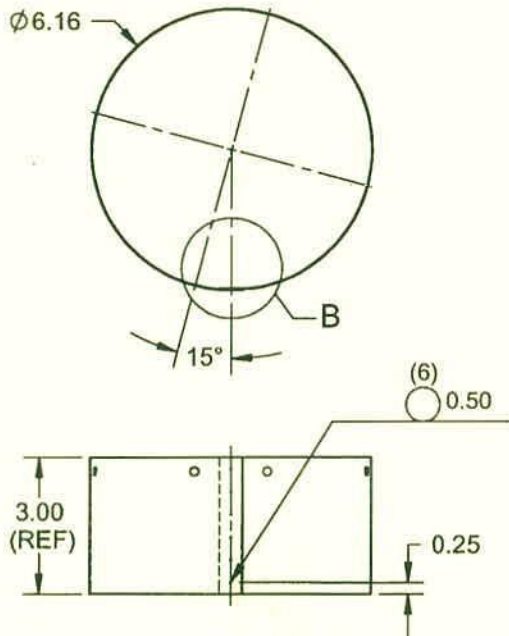
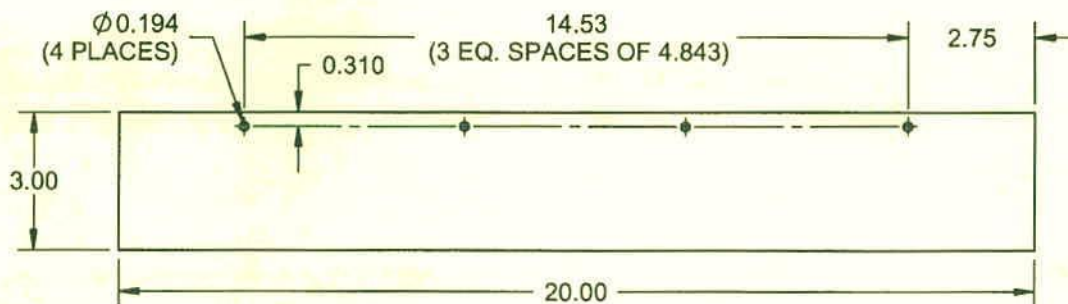
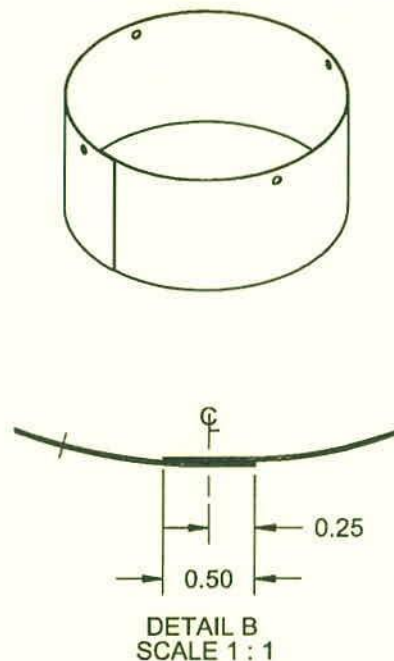
QTY -043	P/N	DESCRIPTION
X	D3476-043	BLOWER MOTOR ADAPTER WELDMENT
1	D3476-1	DUCT
1	D3476-3	DOME
2	D3476-7	TUBE
4	NAS1031C3W	NUTPLATE

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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:4

**D3476-1 DUCT****D3476-1F DUCT FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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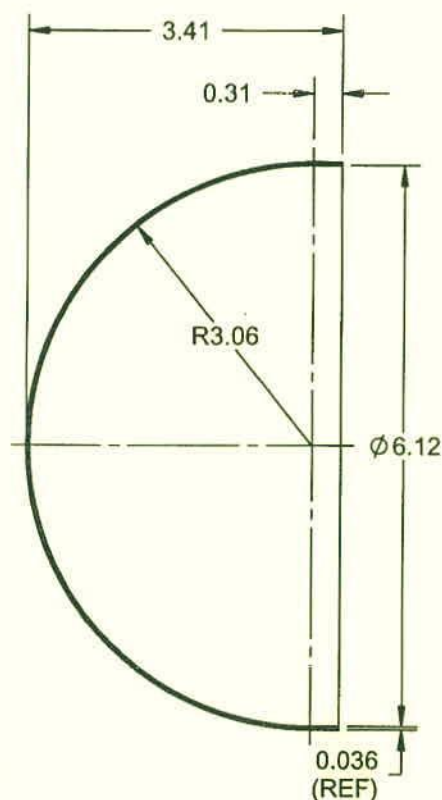
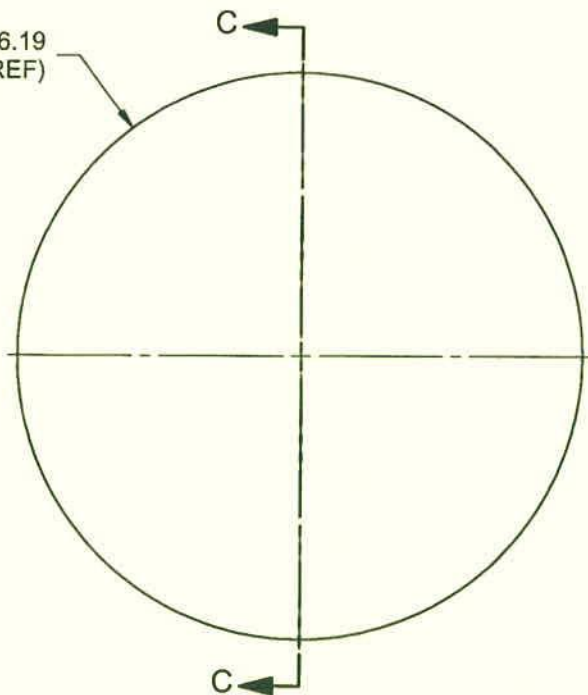
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

RELEASED

06.04.03 *[Signature]* $\varnothing 6.19$
(REF)**SECTION C-C****D3476-3S DOME, SPINNING DETAIL****NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.036 THICK PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S20GA)
- 2) FORM BY SPINNING TO DIMENSION WITHOUT EXCESS THINNING OF MATERIAL (MINIMUM THICKNESS = 0.025").
- 3) FINISH: NONE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

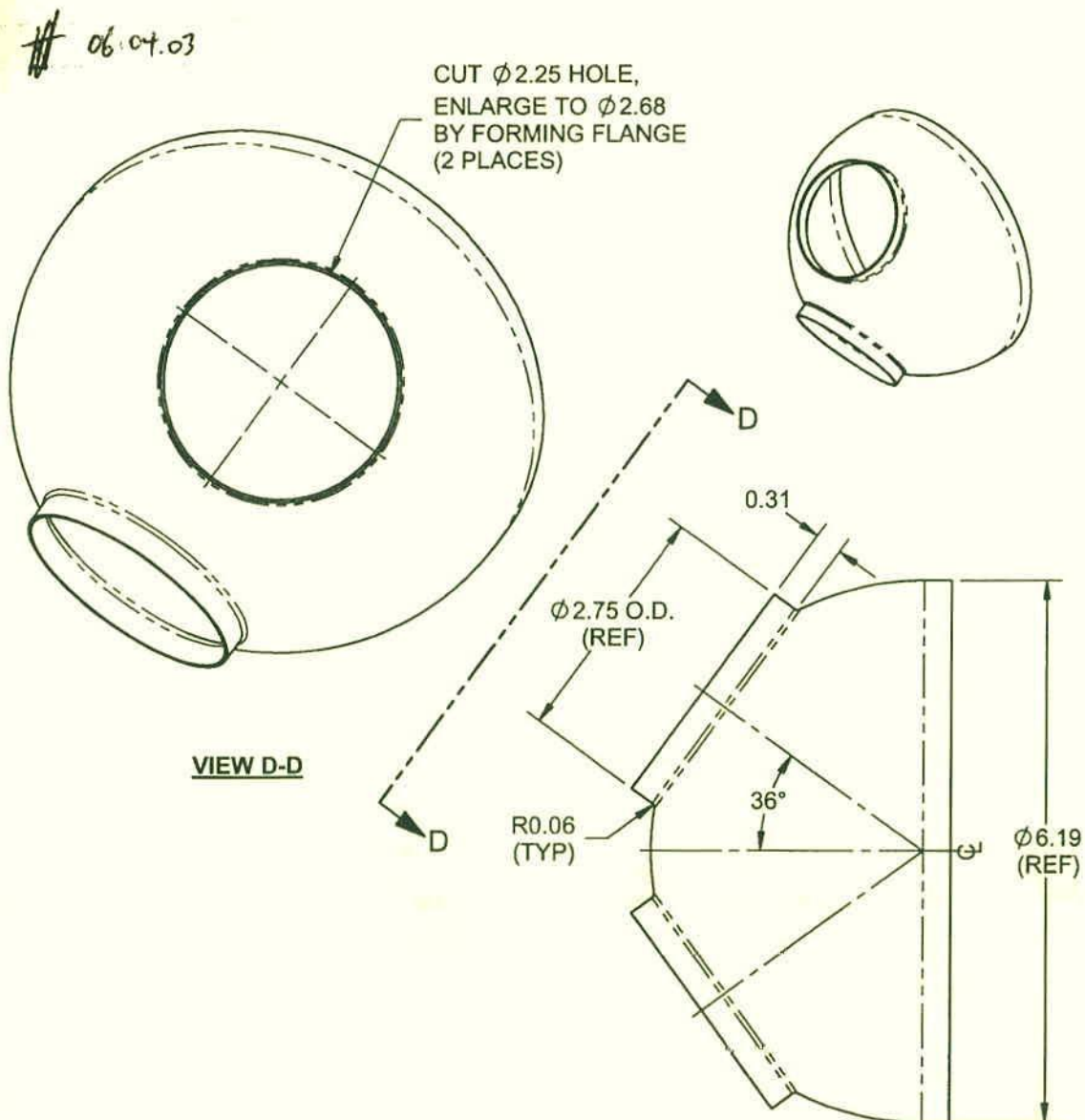
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

**D3476-3 DOME****NOTES:**

- 1) MATERIAL: MAKE FROM D3476-3S
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

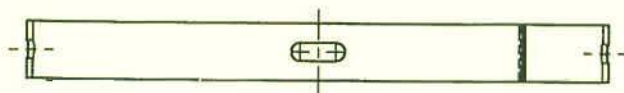
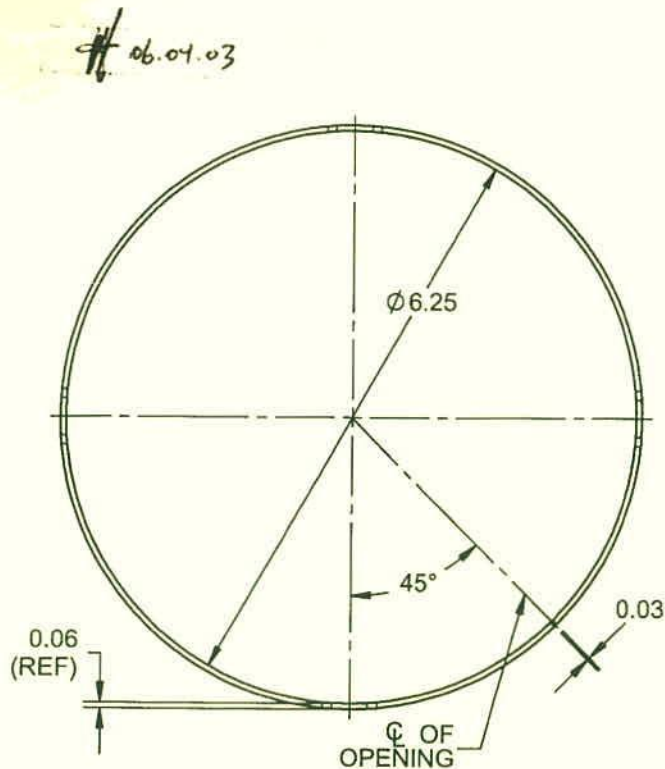
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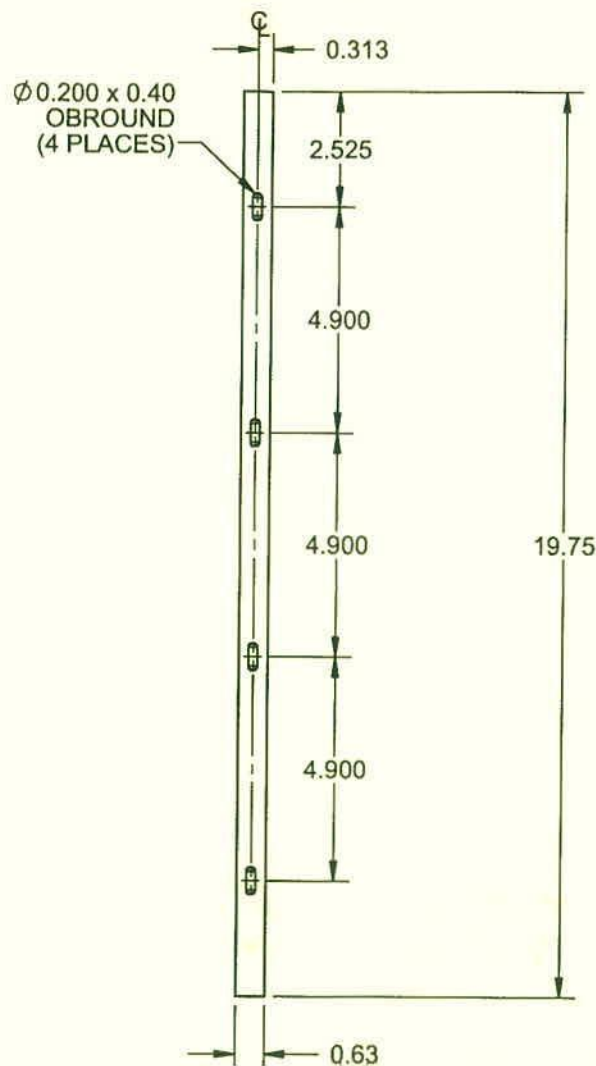
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2



D3476-5 SPACER-RING



**D3476-5F SPACER-RING
FLAT PATTERN**

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET, 0.063 THICK, PER MIL-S-5019 (ANNEALED) 2B FINISH (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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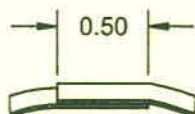
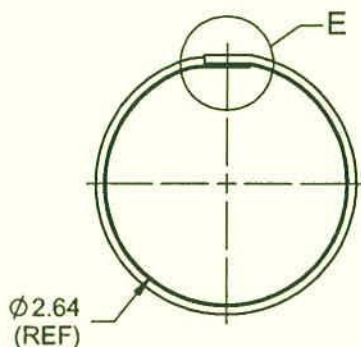
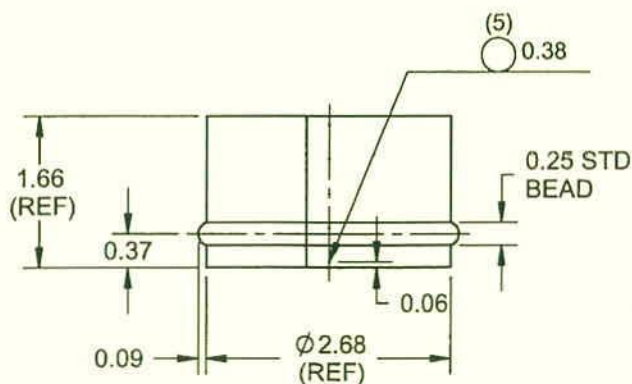
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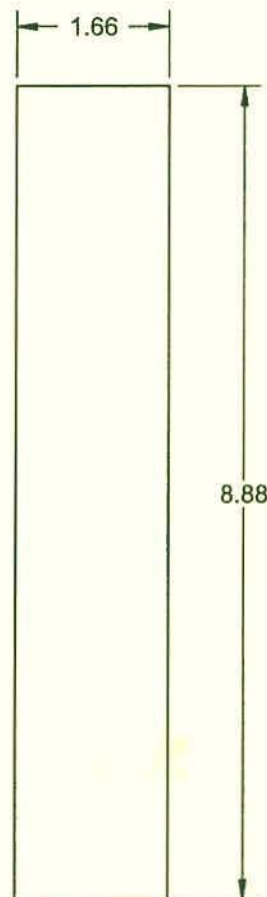
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DATE 06.01.27		TITLE BLOWER MOTOR ADAPTER	SCALE 1:2

[Signature] 06.04.03



DETAIL E
SCALE 1:1

D3476-7 TUBE



D3476-7 TUBE
FLAT PATTERN

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH
26 GAUGE SS (0.018 THICK)
(REF. DART SPEC. M304S26GA)
- 2) SPOT WELD PER DART QSI 004
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
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